

5/29

Work

DART AEROSPACE LTD	Work Order:	23698
Description: Guide	Part Number:	D3112-1
Drawing: D3112 Rev. AT B	Qty:	10

RF 02.11.14

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	RF	05.06.29	10
2	METAL /CNC-CELL	Cut blanks: 0.625" x 1.500 bar x 2.625" long. Material: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8) Bar ref DART spec M6061T6B Batch M17037	SD	05.07.05	10
3	HAAS	Machine as per Folio FA233 Note: Engrave / scribe DART P/N on part as per dwg.	ml	05.07.05	10
4	QC	Inspect Level 2	ml	05.07.05	10
5	QC	Inspect Level 8	En	05.07.05	10
6	METAL/CNC-CELL	Deburr break all unmarked sharp edges .005 to 0.010	ml	05.07.05	10
7	QC	Inspect Level 5	En	05.07.05	10
8	FINISHING	Chemical conversion coat as per QSI 005 4.1	ML	05.07.06	10
9 A	FINISHING	Powder coat grey sandtex (4.3.5.6) per QSI 005 4.3.	ML	05.07.06	10
9 B	QC3	Inspect work to step 9A	h	05.07.06	10
10	STORES	Identify and stock with P/N & S/N using fine point permanent ink marker	h	05.07.06	10
11	EXPEDITING	Close W/O 17.05 Inspect level 21 15.93 Cost/part	RF	05.07.07	10

Rev	Date	Change	Revised By	Approved
A	02.05.22	New Issue	NG	02.05.22

RELEASED

04/05/22

RF
02.12.10
RF
04.11.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

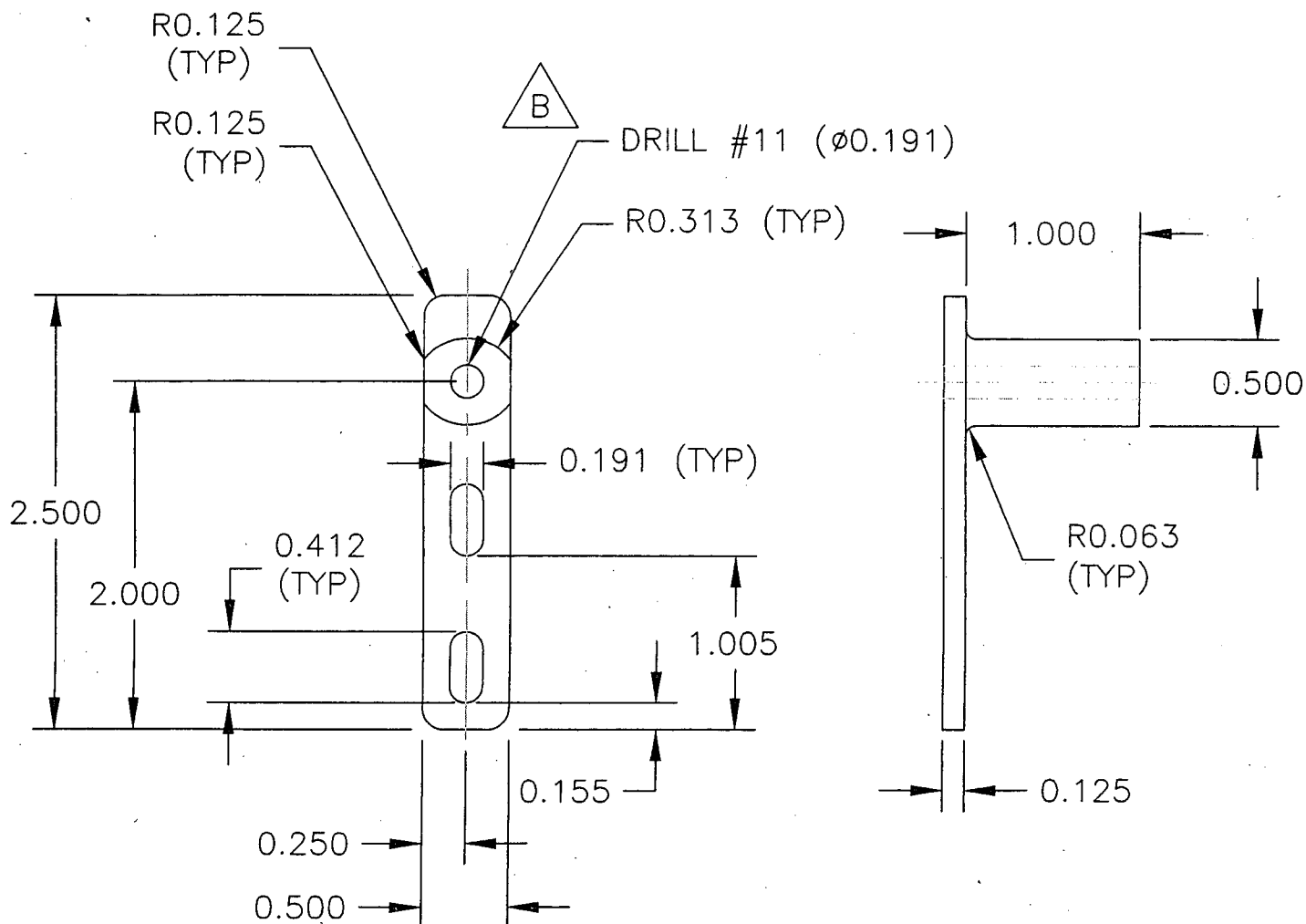
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3112	REV. B SHEET 1 OF 1
DATE 04.10.18		TITLE GUIDE	SCALE 1:1
A	02.04.12	NEW ISSUE	
B	04.10.18	ADD PART MARKING; $\phi 0.191$ WAS $\phi 0.185$	

RELEASED
04.11.23 #



D3112-1 GUIDE

NOTES:

- 1) MATERIAL: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF. DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-17
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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WORK ORDER
NO. 23698

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 28, 2005
10:11 am

Work Order No : 0023698
Project Name : D3112-1
Project For : WK529
Work Order Type : Main
Main WO Number :
House Part Number : D3112-1
Description : Guide
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 06-28-05
Est Finish Date : 07-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 28698
Description: GUIDE		Part Number: 3112-1
Inspection Dwg: D3112 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	± 0.010	1.003	✓		Vern	
0.500	± 0.010	0.501	✓		Vern	
R0.063	± 0.010	R0.063	✓		R-G	
0.125	± 0.010	0.127	✓		Vern	
0.500	± 0.010	0.500	✓		Vern	
0.250	± 0.010	0.250	✓		Vern	
0.155	± 0.010	0.155	✓		Vern	
1.005	± 0.010	1.005	✓		Vern	
0.412	± 0.010	0.410	✓		Vern	
0.191	± 0.010	0.191	✓		Vern	
2.000	± 0.010	2.000	✓		Vern	
2.500	± 0.010	2.500	✓		Vern	
Ø0.191	± 0.005	Ø0.195	✓		Vern	
R0.125	± 0.010	R0.125	✓		R-G	

Measured by: <i>ML</i>	Audited by: <i>SP</i>	Prototype Approval: <i>N/A</i>
Date: 05/07/05	Date: 05/07/05	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	